

5/15

SPLIT

| | | |
|------------------------------------|---------------------|-----------------|
| DART AEROSPACE LTD | Work Order: | 22834A |
| Description: Ø2.750 Support | Part Number: | D2893-1 |
| Dwg: D2893 Rev. A1 | Qty: | 6 72 |
| | | Page 1 of 1 |

3.06.09

| Step | Location | Procedure | By | Date | Qty |
|------|----------|---|-----|----------|-----|
| 1 | DC | Issue Traveller. Blank size makes (2) D2893-1 Dwg not required | HA | 05.03.23 | 10 |
| 2 | PG | Issue P/O: 22834787 Description: D6104-005 Material: 17-4 PH SS (AMS 5643 OR AISI 630) as per Dwg D6104 Material release note required. | U | 05.03.24 | 10 |
| 3 | RG | Receive and inspect for raw material dimensions. Ensure material release note is attached. | CL | 05/04/04 | 10 |
| 4 | MS | Turn blank for Haas as per Folio FA081 | mf | 05/04/05 | 3 |
| 5 | QC1 | Inspect all dimensions as per Dwg D2893 | mf | 05/04/06 | 3 |
| 6 | MV | Machine as per Folio FA081 | mf | 05/04/12 | 3 |
| 7 | MV | Tumble & Deburr | mf | 05/04/12 | 3 |
| 8 | QC1 | Inspect all dimensions to inspection sheet as per Dwg D2893 | mf | 05/04/12 | 3 |
| 9 | QC8 | Inspect dimensions for second check | Er | 05/04/12 | 3 |
| 10 | FP | Powder Coat White (4.3.5.2) per QSI 005 4.3 | MM | 05 04 12 | 3 |
| 11 | QC3 | Inspect Powder Coat | CL | 05/04/14 | 36 |
| 12 | ST | Identify and stock | CL | 05/04/14 | 36 |
| 13 | AC | Cost / part 123.95 | Soc | 05.04.19 | 6 |
| 14 | DC | Close W/O 122.18 Inspect Level 21 | HA | 05.04.19 | 6 |

| Rev | Date | Change | Revised By | Approved |
|-----|----------|---------------------|------------|----------|
| A | 01.01.08 | Preliminary Issue | EC | |
| B | 01.07.19 | Heat treat removed | NG | |
| C | 02.11.26 | Reformat; Added P/O | KJ / RF | RF |

RELEASED

02.11.29 RF

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|--------------------------------------|-----------------------------|
| AEROSPACE LTD | Work Order: 22834 |
| Description: Ø2.750 Support | Part Number: D2893-1 |
| Inspection Dwg: D2893 Rev. A1 | Page 1 of 1 |

Inspect dimensions highlighted on inspection sheet drawing D2893 Rev A1/DSK078 Rev A and record below:

| | | | | Recorded Actual Dimensions | | | | | |
|----------------------|-------|-------|----------------|----------------------------|-------|-------|---|----|------|
| Dim | Min | Max | Go/No Go Gauge | 1 | 2 | 3 | 4 | By | Date |
| Lathe Section | | | | | | | | | |
| A | 2.707 | 2.712 | | 2.712 | 2.711 | 2.712 | | | |
| B | 4.946 | 4.966 | | 4.955 | 4.964 | 4.956 | | | |
| C | 3.064 | 3.084 | | 3.075 | 3.073 | 3.075 | | | |
| D | 0.718 | 0.738 | | 0.725 | 0.726 | 0.726 | | | |
| E | 0.090 | 0.110 | | 0.104 | 0.101 | 0.101 | | | |
| F | 2.934 | 2.954 | | 2.947 | 2.946 | 2.946 | | | |
| G | 2.166 | 2.186 | | 2.177 | 2.182 | 2.173 | | | |
| H | 3.890 | 3.910 | | 3.900 | 3.899 | 3.900 | | | |
| I | 0.914 | 0.934 | | 0.928 | 0.927 | 0.930 | | | |
| J | 0.022 | 0.042 | | 0.032 | 0.032 | 0.032 | | | |
| K | 0.109 | 0.129 | | 0.115 | 0.116 | 0.115 | | | |
| L | | | | | | | | | |
| HAAS Section | | | | | | | | | |
| AA | 2.985 | 3.005 | | 3.000 | 2.995 | 2.995 | | | |
| AB | 0.440 | 0.460 | | 0.440 | 0.440 | 0.440 | | | |
| AC | 0.125 | 0.160 | | 0.136 | 0.150 | 0.140 | | | |
| AD | 0.040 | 0.060 | | 0.040 | 0.040 | 0.040 | | | |
| AE | 0.188 | 0.193 | DT8706 | 0.189 | 0.190 | 0.188 | | | |
| AF | 0.125 | 0.160 | | 0.143 | 0.147 | 0.145 | | | |
| AG | 0.140 | 0.160 | | 0.151 | 0.147 | 0.149 | | | |
| AH | 1.360 | 1.400 | | 1.386 | 1.389 | 1.381 | | | |
| AI | 0.040 | 0.060 | | 0.045 | 0.042 | 0.045 | | | |
| AJ | 1.190 | 1.230 | | 1.227 | 1.223 | 1.220 | | | |
| AK | 0.010 | 0.020 | | 0.010 | 0.010 | 0.010 | | | |
| AL | 0.053 | 0.073 | | 0.063 | 0.063 | 0.063 | | | |
| AM | 0.240 | 0.260 | | 0.250 | 0.250 | 0.250 | | | |
| AN | 2.518 | 2.538 | | 2.528 | 2.528 | 2.528 | | | |
| AO | 84.39 | 90.39 | DT8699 | ✓ | 87 ✓ | ✓ | | | |
| AP | 0.257 | 0.262 | DT8683 | 0.257 | 0.258 | 0.258 | | | |
| AQ | 0.053 | 0.073 | | 0.062 | 0.063 | 0.063 | | | |
| AR | | | | | | | | | |
| AS | | | | | | | | | |
| Accept/Reject | | | | | | | | | |

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|--------------|----------|
| Measured by: | ml |
| Date: | 05/04/06 |

| | |
|-------------|----------|
| Audited by: | Er |
| Date: | 05/04/12 |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|------------|----------|
| A | 02.12.13 | New Issue | KJ/RF | RE |

RELEASED
03.07.01